

Tuesday, May 02, 2017 7:28:58 AM

160564

Page 1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Patient Stop Assembly

Stop *NS2*

Start Date: 5/4/2017 **Start Qty:** 4.00

4

Cust Item ID:

Required Date: 5/11/2017 **Req'd Qty:** 4.00

4

Customer:

Reference: SCHEDULED/S

Approvals: **Process Plan:**

21

Date **MAY 02 2017**

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Draw Nbr	Revision Nbr
D4812	B

100

0.00

100

FLOW WATER JET

1.12

Waterjet

Memo

FLOW CNC Waterjet

1- Cut D4812-1F as per Dwg

Dwg Rev: 6

Prog Rev:

2- DEBURR

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.04

Quality Control

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐					
OTHER : ☐									

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[illegible]

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
								Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	

Root Cause				FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐		
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐		
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐		
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐		
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐		
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐		
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐		
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐		
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐		
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐		
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____					
Misidentified ☐	Past Due ☐						

Work Order ID 160564

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160564

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Item ID: D4812-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Patient Stop Assembly
Start Date: 5/4/2017 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 5/11/2017 Req'd Qty: 4.00 ***4*** Customer:
Reference: SCHEDULED/S

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Chemical Conversion Coat per QSI005 4.1	0.00							
150	HandFinish	Memo				(X4)	Ø		20170516
	Hand Finishing								BEB.
160	QC7-Inspect Chemical Conversion Coat	0.00							
160	QC	Memo							
	Quality Control								4 Ø 17-05-16 D48 34 9-88
170	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
170	Powdercoat	Memo							
	Powder Coating								
		START TIME: 8:50							
		OVEN TEMPERATURE: 320°							
		FINISH TIME: 11:20							

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		OTHER : _____					

Work Order ID 160564

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160564

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Revision ID: Stop ***NS2***
Item Name: Patient Stop Assembly
Start Date: 5/4/2017 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 5/11/2017 Req'd Qty: 4.00 ***4*** Customer:
Reference: SCHEDULED/S

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 *180* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.04				<u>4</u>			DAS 38 9-20 MAY 17 2017
190 *190* Small Fab Small Fab	Memo ASSEMBLE AS PER DWG	0.00 0.90				<u>4</u>	<u>0</u>		DAS 19 2-20 30 MAY 25 2017 DAS 19 2-20
200 *200* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.08				<u>4</u>			DAS 38 9-20 MAY 30 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐																																																																

Work Order ID 160564

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160564

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Item ID: D4812-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Patient Stop Assembly
Start Date: 5/4/2017 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 5/11/2017 Req'd Qty: 4.00 ***4*** Customer:
Reference: SCHEDULED/S

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210	Identify as per dwg & Stock Location: <u>GA</u>	0.00							
210									
Packaging	Memo	0.04			DAS 30 9-89	4			MAY 30 2017
Packaging									
220	QC21- Final Inspection - Work Order Release	0.00							
220									
QC	Memo	0.40							17/5/31 98
Quality Control									

DAS
21
9-89

MAY 30 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐					
OTHER : ☐									

Picklist Print

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Page 1

Work Order ID: 160564

160564

Parent Item: D4812-041

D4812-041

Parent Item Name: Patient Stop Assembly

Start Date: 5/4/2017

Required Date: 5/11/2017

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A 13.05.21 AS PER DWG REV.A VERF:JLM IPP
REV:B 16.04.19 AS PER DWG REV.B VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2690-6 *D2690-6* Lanyard		Manufactured	No			190	Each	57.0000	2	8			
									**	DAS 30 9-89			MAY 30 2017

Location	Loc Qty	Loc Code
ST009	57	
159061	21	
159468	30	
159526	6	

D4811-1 *D4811-1* Pin, Quick Release		Manufactured	No			190	Each	13.0000	2	8			
									**	DAS 30 9-89			MAY 30 2017

Location	Loc Qty	Loc Code
GA	13	
151526	3	
159138	10	

M6061T6S.063 *M6061T6S 063* 6061-T6 .063 Sheet		Purchased	No			100	sf	208.9460	2.03	8.547368			
									**	DAS 30 9-89	10	05/17/02	

Location	Loc Qty	Loc Code
MAT021	208.946	
M134604	57.77	
M134830	2.456	
M136251	31.9	
M136790	9.9	
M136806	9.2	
M137041	47.72	
M137175	50	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER :			
Misidentified ☐	Past Due ☐																																																																

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Work Order ID: 160564

160564

Parent Item: D4812-041

D4812-041

Parent Item Name: Patient Stop Assembly

Start Date: 5/4/2017

Required Date: 5/11/2017

Start Qty: 4.00

Required Qty: 4.00

MS21042L3 Purchased No 190 Each 1,548.000 2 **DAS** 8 **MAY 30 2017**
MS21042L3 **** 30 9-89**
Nut

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP001	91	
m135945	91	
GA	464	
m134360	102	
M136665	362	8
ST303	993	
m137073	11	
m137166	3	
m137321	979	

MS27039-1-07 Purchased No 190 Each 74.0000 2 **DAS** 8 **MAY 30 2017**
MS27039-1-07 **** 30 9-89**
Screw

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
GA	48	
m137320	48	8
ST281	26	
m135948	26	

DQA: _____ Date: _____



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Work Order ID: 160564

160564

Parent Item: D4812-041

D4812-041

Parent Item Name: Patient Stop Assembly

Start Date: 5/4/2017

Required Date: 5/11/2017

Start Qty: 4.00

Required Qty: 4.00

NAS1149D0332J

Purchased

No

190

Each

697.0000

6

24

NAS1149D0332.J

Washer

****** **DAS**
30
9-89

MAY 30 2017

Location

Loc Qty

Loc Code

FP	260
m136015	8
m137075	252
FP001	15
m137075	15
GA	138
m136643	138
ST264	284
m136015	0
m136643	284

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DQA: _____ Date: _____



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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																									
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER :			
Misidentified ☐	Past Due ☐																																																																

DART AEROSPACE LTD		Work Order:	160564
Description: Patient Stop		Part Number:	D4812-041
Inspection Dwg: D4812	Rev: B	Page 1 of 1	

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.191	+0.005/-0.001	Ø.193	1		Visual	
Ø0.250	+0.005/-0.001	Ø.253	1		Visual	
Ø1.06	+0.012/-0.001	Ø1.060	1		Tap	
7.50	+/-0.030	7.50	1			
8.94	+/-0.030	8.94	1			
9.13	+/-0.030	9.139	1			
1.00	+/-0.030	1.003	1			
3.50	+/-0.030	3.50	1			
12.50	+/-0.030	12.50	1			
0.50	+/-0.030	.499	1			
10.00	+/-0.030	10.00	1			
8.00	+/-0.030	8.00	1			
0.94	+/-0.030	.94	1			
2.00	+/-0.030	2.00	1			
4.00	+/-0.030	3.999	1			
2.50	+/-0.030	2.499	1			
2.50	+/-0.030	2.497	1			
4.00	+/-0.030	3.999	1			
0.771	+/-0.010	.776	1			
1.763	+/-0.010	1.771	1			
4.750	+/-0.010	4.749	1			
32.0	+/-0.100	32.0	1			
5.00	+/-0.030	5.009	1			
1.00	+/-0.030	1.00	1			

Measured by:	ac	Checked by:	DAS 38	QC Inspector:	
Date:	17/09/02	Date:	MAY 13 2017	Date:	

Engineering Approval: (If necessary)		Date:	
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Rev	Date	Change	Revised by	Approved
A	15.04.27	New Issue	KJ	
B	16.06.24	Dwg Rev updated	KJ	

D4811-1
QUICK RELEASE PIN
2 PL

D2690-6
6" LANYARD ASSY
2 PL

D4812-1
PATIENT STOP

MS27039-1-07 SCREW
NAS1149D0332J WASHER (X3)
MS21042L3 NUT
2 PL

D4812-041 PATIENT STOP ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 6.1
- 7) WEIGHT: 1.08 lbs

RELEASED
2016-04-18
ECN 16-62

ITEM	QTY -041	P/N	DESCRIPTION
	X	D4812-041	PATIENT STOP ASSEMBLY
1	2	D2690-6	6" LANYARD ASSY
2	2	D4811-1	QUICK RELEASE PIN
3	1	D4812-1	PATIENT STOP
4	2	MS21042L3	NUT, SELF-LOCKING
5	2	MS27039-1-07	SCREW, PAN-HEAD
6	6	NAS1149D0332J	WASHER

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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 160564 MW
1705-01

B	MS27039-1-07 WAS MS27039-1-13, REF. PAR13-292	MB	14.01.30
A	NEW ISSUE	DB	13.03.20
REV.	DESCRIPTION	BY	DATE
DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	MB		
CHECKED	AJS	DRAWING NO.	REV. B
MFG. APPR.	DD	D4812	SHEET 1 OF 2
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	PATIENT STOP	NTS
DATE	14.01.30	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

